



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4909-1TRN
Job Sheet 169899



Part No: D4909-1TRN

Job Qty: 4 ea

Part Name: Support Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Due Date: 1/19/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A SHEET 3 IPP REV:A NEW ISSUE 13-04-24 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		1/18/18	0.00	0.00	Start Up Machining-3		
100	Doosan	4 pcs		1/19/18	0.00	11.23	Doosan		
110	QC	4 pcs		1/19/18	0.00	0.00	QC2 Machining-3		
120	QC	4 pcs		1/19/18	0.00	0.00	QC8 Machining-3		
130	Packaging	4 pcs		1/19/18	0.00	0.00	Packaging1-5		
140	QC21-SA	4 Ea		1/19/18	0.00	0.00	QC21		

Part Op 100 - Turn blank as per Folio FB189 ENSURE TO TEST FIT ID BORE WITH 4TH AXIS PLUG /FIT MUST SNUG****
Descriptions: 130 - LOCATION: MAT060

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6104-011	4	22	0	0

Part Specifications

Specifications could not be found.

Plex 1/3/18 8:56 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermofor ☐ Large ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod Eng Coord ☐ Engineering ☐ Quality ☐ Other ☐																																																																																									
Date : _____		Step #: _____		QTY: _____																																																																																									
Description Work Order Deviation																																																																																													
Root Cause <table style="width:100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table> <table style="width:100%;"> <tr><td>Pressure/Forced</td><td>☐</td><td>Temperature/C</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td><td>Set-up</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td><td>BOM/Route</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td><td>Broken/Damage</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incc</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incc</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td></tr> </table>						Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	Pressure/Forced	☐	Temperature/C	☐	Bending	☐	Set-up	☐	Centre Not Concentric	☐	BOM/Route	☐	Cracks	☐	Broken/Damage	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incc	☐	Cuffs	☐	Contamination	☐	Crushing	☐	Countersink	☐	Heat Treat	☐	Cut Too Short	☐	Wave/Twist in Tube	☐	Instructions Incc	☐	Marks/Chatter	☐	Drill Holes	☐
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 CANADA
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 www.dartaerospace.com

DART
AEROSPACE
S039297

Support Turning Detail

PART NO: D4909 - 1TRN
Original Serial #: S039297
Revision:
Operation:
Change No:

Start up Operation 02/06/18
Job No: 169899

2) Approval _____

 ed By _____

 Supervisor _____
 rification _____

 rdinator _____
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 Wrong _____
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 tolerance _____
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DART AEROSPACE LTD		Work Order:	169899
Description: Turning Detail for D4909-1		Part Number:	D4909-1TRN
Inspection Dwg: D4909	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Milling Section								
A-A	3.268	3.288		3.281	3.282	3.280	3.280	
B-B	1.250	1.270		1.258	1.258	1.258	1.258	
C-C	3.990	4.010		4.000	4.000	4.000	4.000	
D-D	0.718	0.738		0.728	0.728	0.728	0.728	
E-E	0.150	0.170		0.157	0.157	.158	.158	
F-F	0.090	0.110		0.097	0.097	.099	.099	
G-G	0.090	0.110		0.100	0.100	0.100	.100	
H-H	R0.022	R0.042		.032	.032	.032	.032	
I-I	R0.240	R0.260		.250	.250	250	.250	
J-J								
K-K								
L-L								
M-M								
N-N								
O-O								
P-P								

Measured by:	P 18-02-06	Date:	
Audited by:		Date:	
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.07	New Issue	KJ	

